

Date: Thursday, 31/07/2008 1:55:50 PM
 User: Julie Lecocq

Process Sheet

Customer	: CU-DAR001 Dart Helicopters Services	Drawing Name	: FRONT RAIL, RH
Job Number	: 40864		
Estimate Number	: 13493		
P.O. Number	:	Part Number	: D37662
This Issue	: 31/07/2008 S.O. No. :	Drawing Number	: D3766 REVB
Prsht Rev.	: NC	Project Number	: N/A
First Issue	: 31/07/2008 Type : SMALL /MED FAB	Drawing Revision	: B
Previous Run	: 40709	Material	:
Written By	:	Due Date	: 08/08/2008 Qty: 10 Um: Each
Checked & Approved By	: <u>DD 08.8.01</u>		
Comment	: Est Rev:A 08-07-21 revB as per dwg DD verified by:EC		

Additional Product

Job Number:



Seq. #:

Machine Or Operation:

Description :

1.0

M6061T6T1000W188

6061T6 RD-TUBE 1.00 X .188W



Comment: Qty.: 2.9323 f(s)/Unit Total: 20.5263 f(s)

6061T6 RD TUBE 1.00 X .188W

batch:

M104 480 (4)

SAD 08/08/13

(10)

2.0

SMALL FAB 1

SMALL & MEDIUM FAB RESOURCE 1



Comment: SMALL & MEDIUM FAB RESOURCE 1

1-cut tube to length as per dwg D3766

2-drill holes thru to finish size as per dwg D3766

3- deburr

SAD 08/08/13

08/08/13

(10)

3.0

QC5

INSPECT WORK TO CURRENT STEP



Comment: INSPECT WORK TO CURRENT STEP

SAD 08/08/13

4.0

HAND FINISHING1

HAND FINISHING RESOURCE #1



Comment: HAND FINISHING RESOURCE #1

Chemical Conversion Coat as per QSI 005 4.1

M104 10.08.19

10.08.19

(10)

5.0

QC3

INSPECT POWDER COAT/CHEMICAL CONVERSION



Comment: INSPECT POWDER COAT/CHEMICAL CONVERSION

SAD 08-08-19

W/O:		WORK ORDER CHANGES					
DATE	STEP	PROCEDURE CHANGE	By	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector

Part No: D 3766-2 PAR #: N/A Fault Category: FAB - med / sm NCR: Yes No DQA: AS Date: 08.08.21
DY12-765-044 QA: N/C Closed: D Date: 08/08/26

NCR: <u>40864</u>		WORK ORDER NON-CONFORMANCE (NCR)						
DATE	STEP	Description of NC Section A	Corrective Action Section B			Verification Section C	Approval Chief Eng	Approval QC Inspector
			Initial Chief Eng	Action Description Chief Eng	Sign & Date			
<u>08.08.18</u>	<u>2.0</u>	<u>Drilled hole at wrong orientation Operator Error.</u>	<u>[Signature]</u>	<u>Weld hole AL Rod Batch: M106330</u>	<u>[Signature]</u> <u>08/08/18</u>	<u>[Signature]</u> <u>08/08/18</u>	<u>[Signature]</u> <u>08/08/18</u>	<u>[Signature]</u> <u>08/08/18</u>

NOTE: Date & initial all entries

Date: Thursday, 31/07/2008 1:55:50 PM
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Process Sheet

Customer: CU-DAR001 Dart Helicopters Services

Drawing Name: FRONT RAIL, RH

Job Number: 40864

Part Number: D37662

Job Number:



Seq. #:

Machine Or Operation:

Description :

6.0

PACKAGING 1

PACKAGING RESOURCE #1



Comment: PACKAGING RESOURCE #1

Identify and Stock

Location: BT

mf 08-08-19

7.0

QC21

FINAL INSPECTION/W/O RELEASE



08/08/2008

Comment: FINAL INSPECTION/W/O RELEASE

Job Completion



mf 08-08-19

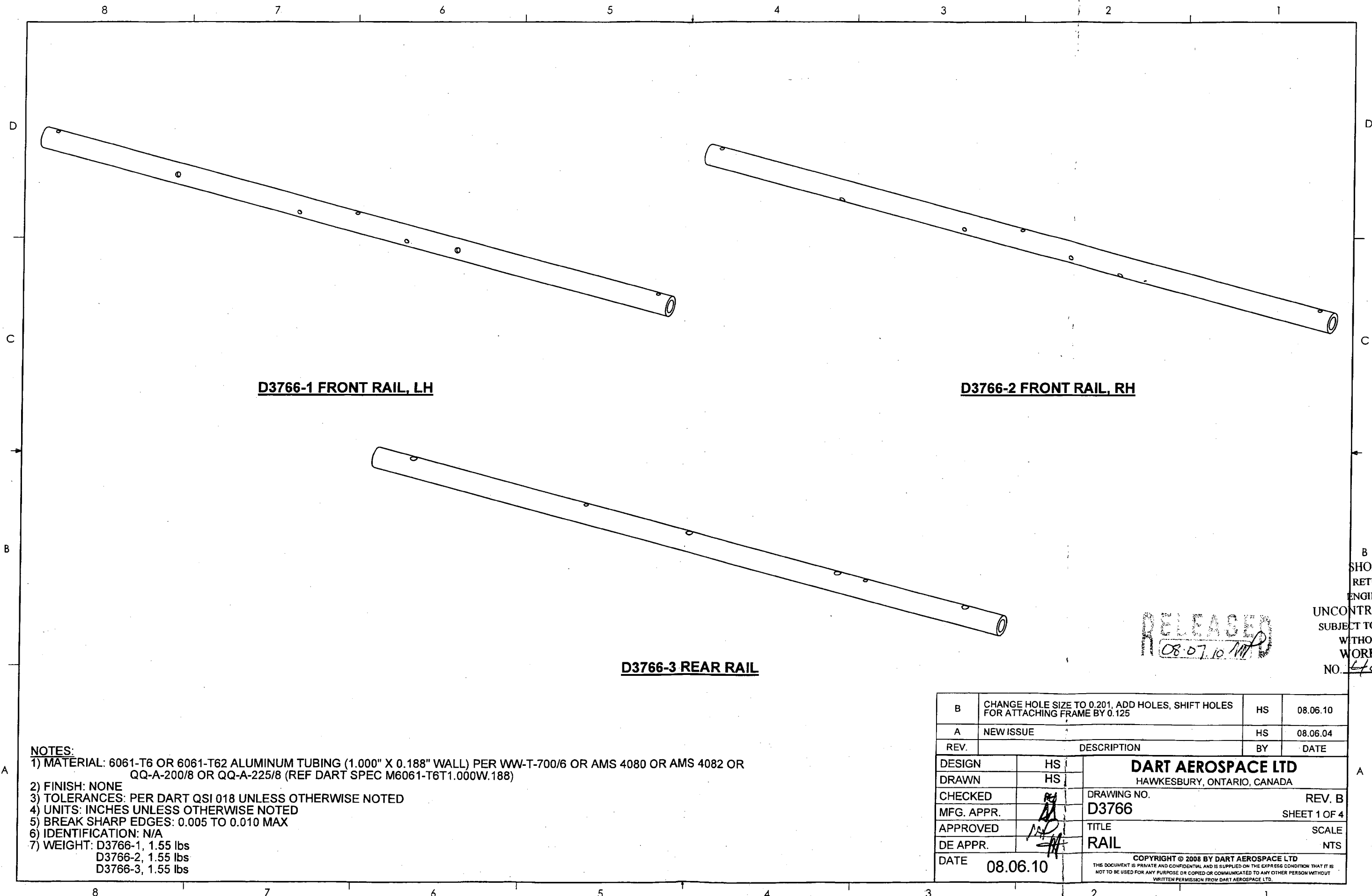
W/O:		WORK ORDER CHANGES					
DATE	STEP	PROCEDURE CHANGE	By	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector

Part No: _____ PAR #: _____ Fault Category: _____ NCR: Yes No DQA: _____ Date: _____

QA: N/C Closed: _____ Date: _____

NCR:		WORK ORDER NON-CONFORMANCE (NCR)						
DATE	STEP	Description of NC Section A	Corrective Action Section B			Verification Section C	Approval Chief Eng	Approval QC Inspector
			Initial Chief Eng	Action Description Chief Eng	Sign & Date			

NOTE: Date & initial all entries



D3766-1 FRONT RAIL, LH

D3766-2 FRONT RAIL, RH

D3766-3 REAR RAIL

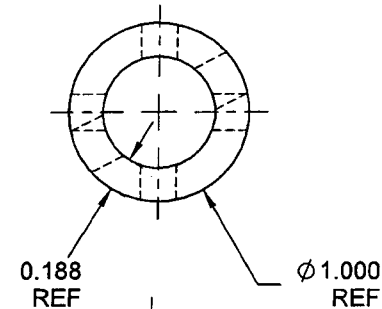
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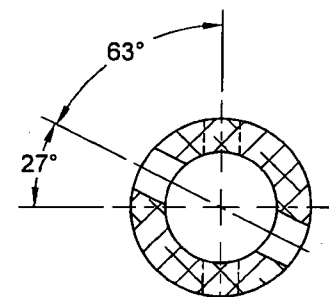
NOTES:

- 1) MATERIAL: 6061-T6 OR 6061-T62 ALUMINUM TUBING (1.000" X 0.188" WALL) PER WW-T-700/6 OR AMS 4080 OR AMS 4082 OR QQ-A-200/8 OR QQ-A-225/8 (REF DART SPEC M6061-T6T1.000W.188)
- 2) FINISH: NONE
- 3) TOLERANCES: PER DART QSI 018 UNLESS OTHERWISE NOTED
- 4) UNITS: INCHES UNLESS OTHERWISE NOTED
- 5) BREAK SHARP EDGES: 0.005 TO 0.010 MAX
- 6) IDENTIFICATION: N/A
- 7) WEIGHT: D3766-1, 1.55 lbs
D3766-2, 1.55 lbs
D3766-3, 1.55 lbs

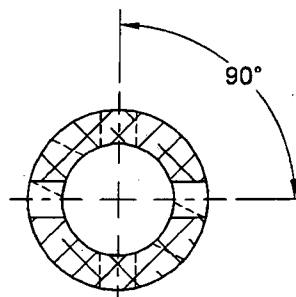
B	CHANGE HOLE SIZE TO 0.201, ADD HOLES, SHIFT HOLES FOR ATTACHING FRAME BY 0.125	HS	08.06.10
A	NEW ISSUE	HS	08.06.04
REV.	DESCRIPTION	BY	DATE
DESIGN	HS	DART AEROSPACE LTD HAWKESBURY, ONTARIO, CANADA	
DRAWN	HS		
CHECKED	MA	DRAWING NO.	REV. B
MFG. APPR.	MA	D3766	SHEET 1 OF 4
APPROVED	MA	TITLE	SCALE
DE APPR.	MA	RAIL	NTS
DATE	08.06.10	COPYRIGHT © 2008 BY DART AEROSPACE LTD THIS DOCUMENT IS PRIVATE AND CONFIDENTIAL AND IS SUPPLIED ON THE EXPRESS CONDITION THAT IT IS NOT TO BE USED FOR ANY PURPOSE OR COMMUNICATED TO ANY OTHER PERSON WITHOUT WRITTEN PERMISSION FROM DART AEROSPACE LTD.	



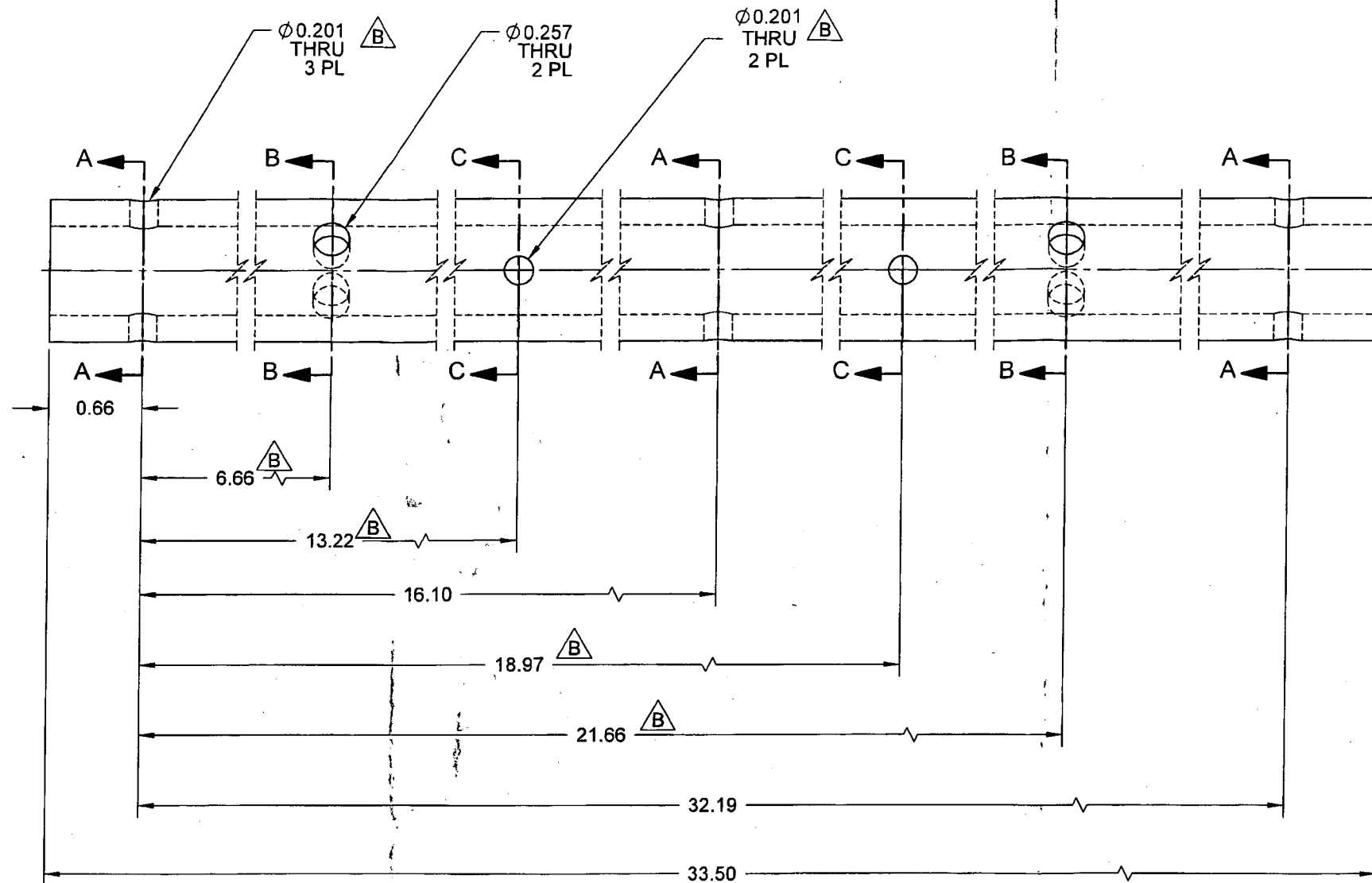
SECTION A-A



SECTION B-B







SECTION C-C

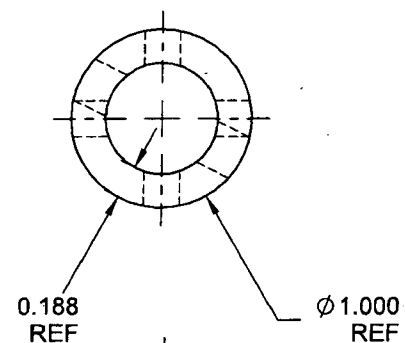


D3766-1 FRONT RAIL, LH

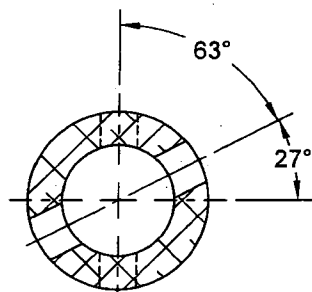
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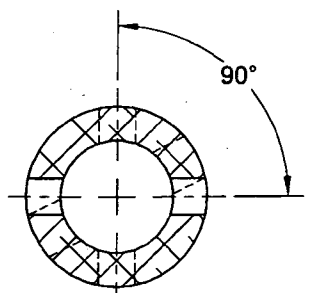
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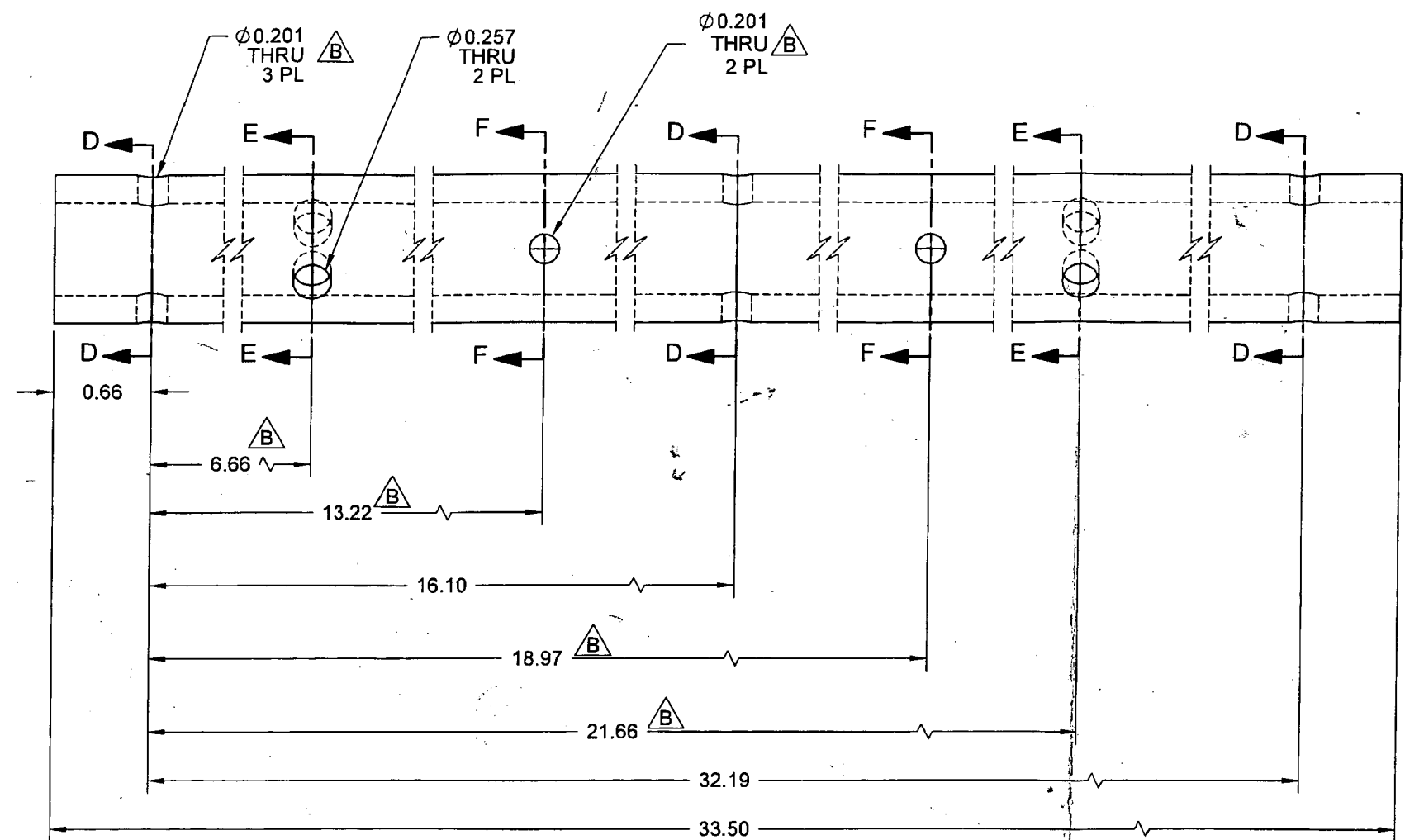
SECTION D-D



SECTION E-E







SECTION F-F



D3766-2 FRONT RAIL, RH

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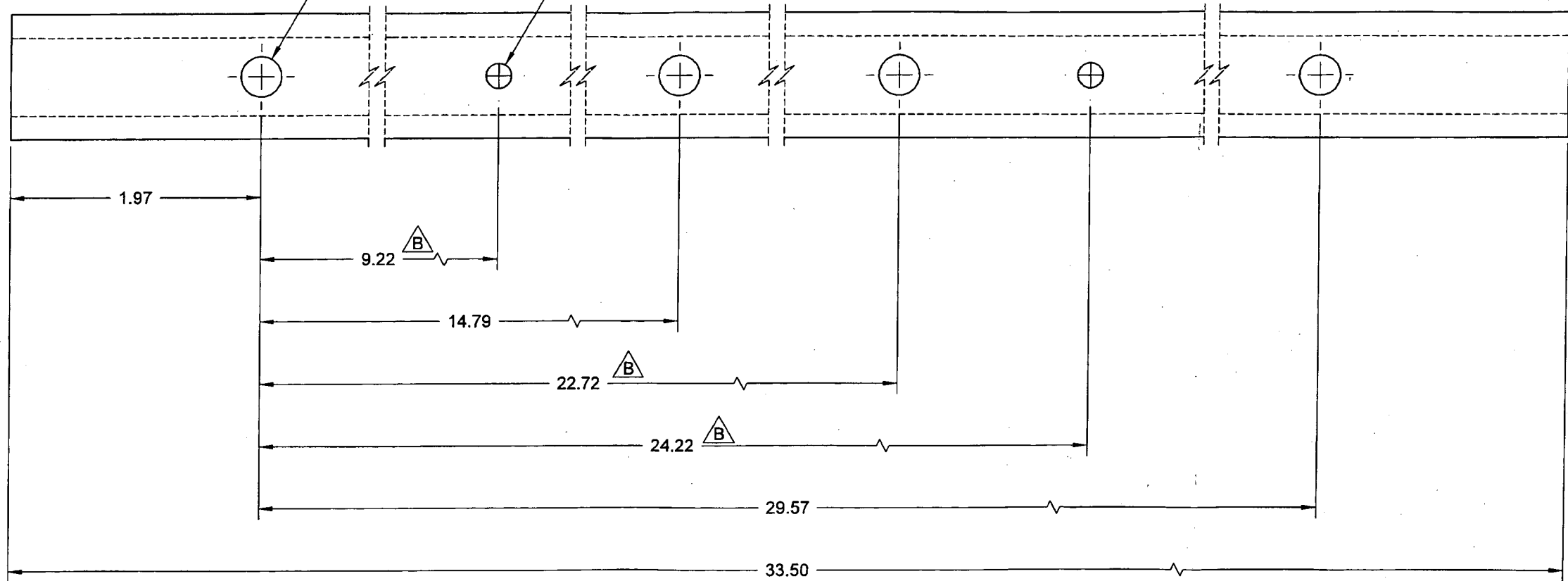
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CHECKED		DRAWING NO.	REV. B
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0.188
REF

Ø1.000
REF

Ø0.323
THRU
4 PL

Ø0.201
THRU
2 PL



D3766-3 REAR RAIL

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NO. 40864

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DRAWN	HS		
CHECKED	HS	DRAWING NO.	REV. B
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